












Date: Wednesday, 12/11/2008 1:37:15 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 43353		
Estimate Number	: 12966		
P.O. Number	:	Part Number	: D3637041
This Issue	: 12/11/2008 S.O. No. :	Drawing Number	: D3637 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL / MED FAB	Drawing Revision	: B
Previous Run	: 42994	Material	:
Written By	:	Due Date	: 21/11/2008 Qty: 20 Um: Each
Checked & Approved By	: <u>JLD 08.11.12</u>		
Comment	Est Rev:A New Issue 07-07-20 JLM Verified By:EC Est Rev:B change to REV.B as per dwg 08-02-11 DD verified by:ec		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304S14GA	304SS sheet .080	
			
Comment: Qty.: 0.0945 sf(s)/Unit Total: 1.8900 sf(s) 304SS .080 Batch: <u>109358</u> <u>HB 8-11-17</u>			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET 1-Cut as per Dwg D3637 Dwg Rev: <u>B</u> <u>HB 8-11-17</u> Prog Rev: <u>B</u> 2-Deburr if necessary <u>HB 8-11-17</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>HB 8-11-17</u>			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <u>S 08/11/18</u> <u>counter</u> <u>+36</u>			
5.0	BRAKE NC	NC BRAKE	
			
Comment: NC BRAKE Form as per Dwg D3637 <u>SB 08/11/18</u> <u>+36</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/11/2008 1:37:15 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 43353

Part Number: D3637041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	MS21059L4	Nutplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s) - 3

Nutplate

BATCH: M 106322

FF 08/12/02

7.0	MS20426AD33	Rivet
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s) - 6

Rivet

BATCH: M 1563

FF 08/12/02

8.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- drill holes as per dwg using DT8979

2-C'Sink as per Dwg D3637

3-Install Nut plate as per Dwg D3637

9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 264

8/12/05

ZZX

SP

11.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/12/08

Job Completion



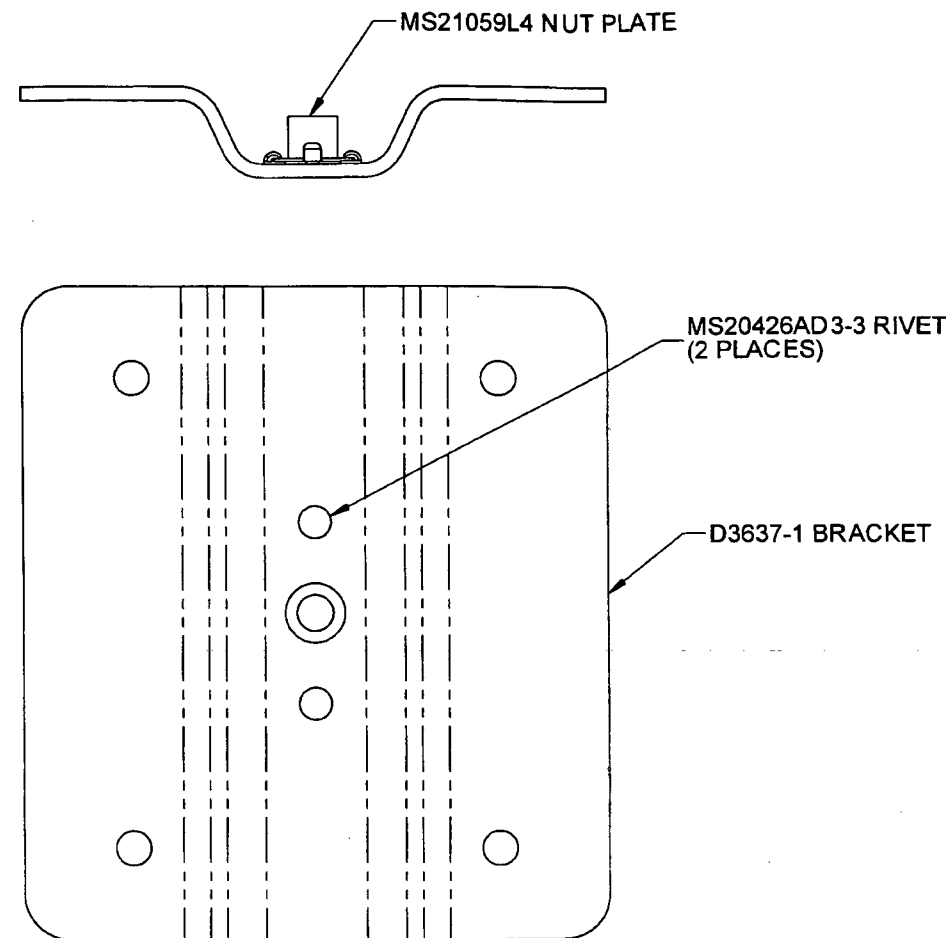
MF 08-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3637-041 PAR #: N/A Fault Category: Prod / ~~Ins~~ ^{long. coord. mfg.} ~~mate~~ ^{fall} NCR: Yes No DQA: D Date: 08/12/09
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 08/12/09

NCR: <u>43353</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-12-04	8.1	14 parts are scrap. 1 hole on each part, @ the 0.600" from the edge dimension, is 0.030" too far in resulting in a 0.630 hole dim. R. Ci. Incorrect hole dimension on the drill sig.	<i>[Signature]</i>	Scrap all 14 parts & no replace. Fill in the holes that are affected on the DT8979 drill sig with magna bond, so they can not be used. Drill one side of the part, flip it, and drill the other side.	<i>[Signature]</i> 08/12/05	<i>[Signature]</i> 08-12-05	<i>[Signature]</i>	<i>[Signature]</i> 08/12/04

NOTE: Date & initial all entries



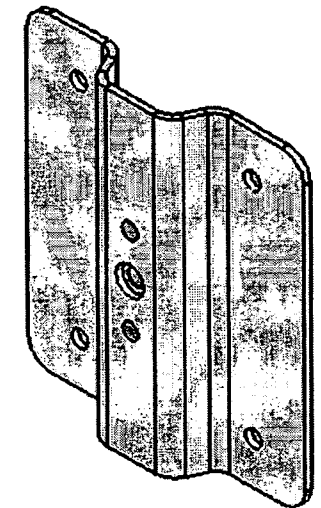
D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)

D3637-041 PARTS:

QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

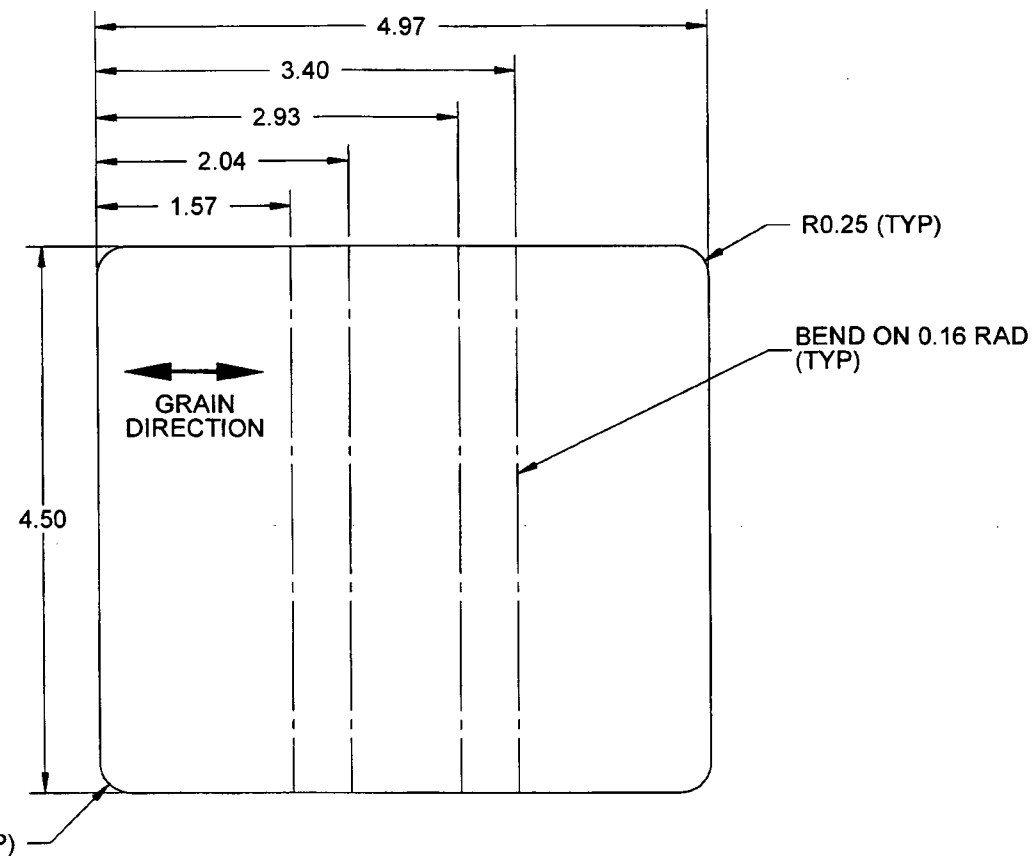
D3637-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

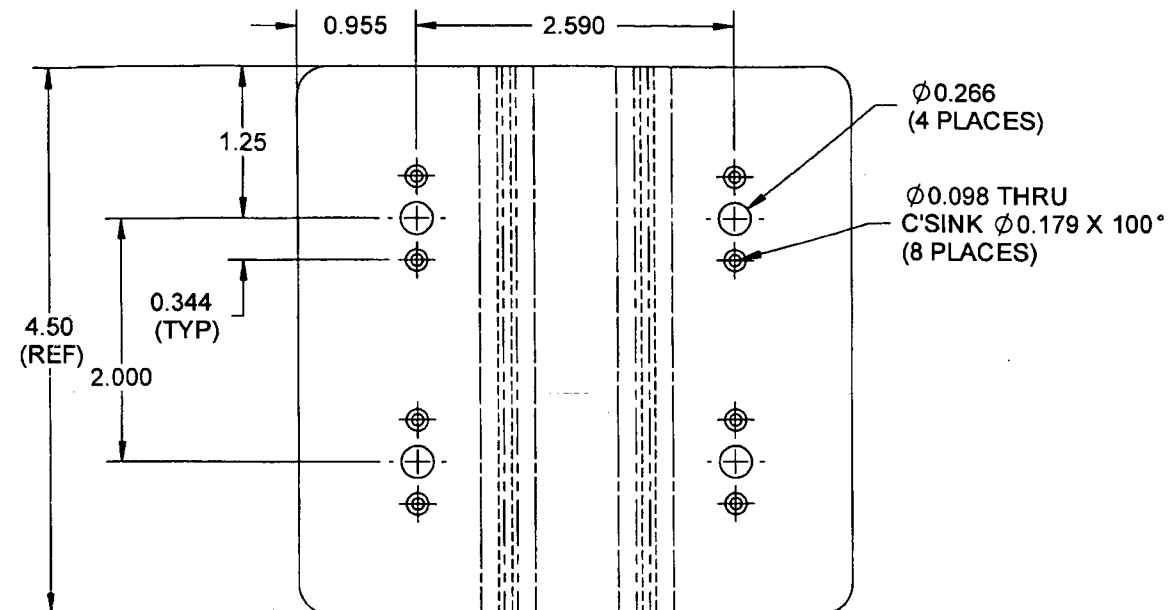
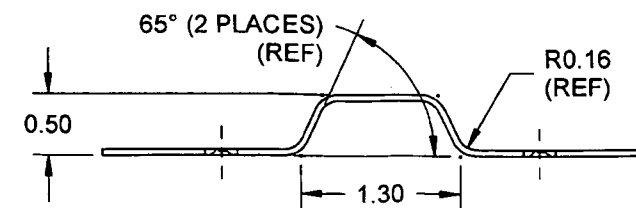


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WITHOUT NOTICE
WORK ORDER
NO. 43353

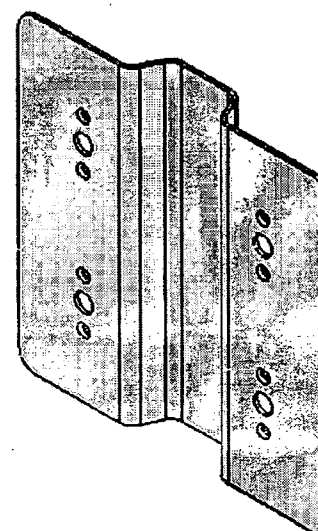
B	FOR D3637-1, 1 15 WAS 1.30 & "REF" REMOVED FROM ANGLE	LE	07.12.18
A	NEW ISSUE; REPLACES G10608, G10602 & G10609	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	LE		
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	EP	D3637	SHEET 1 OF 3
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BRACKET	1:1
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D3637-3F FLAT PATTERN



**D3637-3 BRACKET
(WAS GENEVA P/N G10609-1)**



DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Pf	DRAWING NO.	REV. B
MFG. APPR.	W	D3637	SHEET 3 OF 3
APPROVED	W	TITLE	SCALE
DE APPR.	W	BRACKET	2:3
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- D3637-3 NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.32 lbs

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